

Work Order ID 129557

129557

Page 1

Friday, February 13, 2015 12:39:22 PM

Item ID: D135-751-011 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Skidtube with Standard Wearplates Fits LH or RH
Start Date: 2/13/2015 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 2/13/2015 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: MCS Date: 15-02-13 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3507	Rev D								
DSI 9661	A								

100 Document Control 0.00

100 DOCUMENT CONTROL

DC Memo 0.00 MCS 15-03-16

Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D135-751-011 CHG002

Work Order ID 129557

Friday, February 13, 2015 12:39:22 PM

129557

Page 2

Item ID: D135-751-011

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00

120

Skidtubes

Skidtubes

Memo

0.00

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open all wearplate holes to 0.297"

9-Open ground wire hole .297" section E-E

10-Open Aft & Fwd Cap holes using .208" drill.

11-Bore out aft end of tube as per Dwg D3507 & Detail "B".

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

BE 15-02-24

78E15-02-25

Work Order ID 129557

Friday, February 13, 2015 12:39:22 PM

129557

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
160 *160* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							

DAS
03
9-89

15-2-25

1 8 15-2-25

DAS
18
9-89

1 8 15-02-26

Work Order ID 129557

Friday, February 13, 2015 12:39:22 PM

129557

Page 4

Item ID: D135-751-011

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N900040100

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NS1

Revision ID:

Stop

NS2

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1

Cust Item ID:

Required Date: 2/13/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00

170

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375" (1 Places) & .500" (2 Places) as per Dwg D3507.
and section G-G to .750" (2 places)

BE 15-02-26

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex

Batch:

Exp Date: 13-10-21

start time: _____

end time: _____

BE 15-02-26

5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G

A/R AL ROD

Batch:

M30L37

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

BE 15-02-26

1 29557

Page 5

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

[illegible]

Work Order ID 129557

129557

Page 6

Friday, February 13, 2015 12:39:22 PM

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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210	Pressure Wash per QSI005 4.3	0.00				1		15-3-6	
-----	------------------------------	------	--	--	--	---	--	--------	--

210

HandFinish

Hand Finishing

Memo

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220		0.00				1		CK 150311	
-----	--	------	--	--	--	---	--	-----------	--

220

SprayPaint

Spray Painting

Memo

1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg

A/R Primer Batch: 130992

2- Paint two coats of White paint as per QSI 005 4.2 and dwg

A/R Paint Batch: 131669

SEE ATTACHED

230	QC14- Inspect Spray Paint	0.00				1x		HL 15/03/12	
-----	---------------------------	------	--	--	--	----	--	-------------	--

230

QC

Quality Control

Memo

0.00

DAS
15
9-89

Work Order ID 129557

129557

Page 7

Friday, February 13, 2015 12:39:22 PM

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

260

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

0.00

1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: 11131570

Exp Date: 15/10

3-Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Screws where indicated on Dwg (Note #6)

A/R 241 Sika Flex Batch: 11131570

Exp Date: 15/10

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11131379 RTU 5983611 1125792 exp 15/05

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: 11131659

1x d H 15/03/12

Friday, February 13, 2015 12:39:22 PM

129557

Page 8

Accept

N900040100

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Cust Item ID:

Required Date: 2/13/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							DAG 9-89 38
* 270*									
QC	Memo	0.00							
Quality Control									MAR 13 2015
280	Pick Kit	0.00							
* 280*									
Packaging	Memo	0.00							
Packaging									
					DAS 6 9-89			MAR 14 2015	
290	QC4- 100% Inspect kits for completeness	0.00							
* 290*									
QC	Memo	0.00							
Quality Control						(ix)		DAS 46 9-89	MAR 16 2015

Work Order ID 129557

129557

Page 9

Friday, February 13, 2015 12:39:22 PM

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	Packaging	0.00				(12)	DAS 46	MAR 16 2015	
300	Memo	0.00					9-89		
Packaging	Identify and pack for shipping as per PPP D135-751-011								
Packaging	Location: _____ PPP Rev: _____	Sold							
310	QC21- Final Inspection - Work Order Release	0.00							
310	Memo	0.00							
QC									
Quality Control									

MLJ 1503-16

UMF
15-3-16

Picklist Print

Friday, February 13, 2015 12:39:26 PM

Page 1

Work Order ID: 129557

129557

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A06-06-21New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E
 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F 10.06.09
 remove seq110 DD verf:EC IPP Rev G 10.09.17 added
 D3507-1-bent EC verified by:DD IPP REV:H 13.12.11 ECN13-619/
 CHG002 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130	AELS8-1032-130	Purchased	No				Each	6,426.000		38			
---------------	----------------	-----------	----	--	--	--	------	-----------	--	----	--	--	--

ALS7-1032-130 *ALS7-1032-130* ****** *13/03/12*
 Rivnut

Location	Loc Qty	Loc Code
CA	6	
M128649	6	
CCK003	6320	
M128649	6320	
FG	100	
121444	100	

X38

D3507-1-BENT	Manufactured	No				120	Each	8.0000	1	1			
--------------	--------------	----	--	--	--	-----	------	--------	---	---	--	--	--

D3507-1-BENT ****** *BE15-02-24*
 Skidtube Assembly EC135

Location	Loc Qty	Loc Code
LG002	8	
115439	8	
	170	

1

D3504-1	Manufactured	No				170	Each	10.0000	2	2			
---------	--------------	----	--	--	--	-----	------	---------	---	---	--	--	--

D3504-1 ****** *BE15-03-02*
 Crossbolt Spacer

Location	Loc Qty	Loc Code
LG001	10	
99007	10	

2

Picklist Print

Page 2

Friday, February 13, 2015 12:39:26 PM

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129557

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D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D3504-3 Manufactured No 170 Each 60.0000 1 1

D3504-3

Crossbolt Spacer

BE15-03-02

Location

Loc Qty

Loc Code

LG001

60

105604

53

31232

7

D3504-5 Manufactured No 170 Each 13.0000 2 2

D3504-5

Crossbolt Spacer

BE15-03-02

Location

Loc Qty

Loc Code

LG001

13

106024

13

D3505-1 Manufactured No 170 Each 7.0000 1 1

D3505-1

Web

BE15-02-26

Location

Loc Qty

Loc Code

LG002

7

112204

7

D3506-1 Manufactured No 190 Each 11.0000 4 4

D3506-1

Doubler

BE15-03-04

Location

Loc Qty

Loc Code

LG001

11

106261

11

Picklist Print

Page 3

Friday, February 13, 2015 12:39:26 PM

Work Order ID: 129557

129557

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D3506-3 Manufactured No

190 Each 13.0000 2 2

D3506-3

**

BE 15-03-04

Doubler

Location

Loc Qty

Loc Code

LG001

13

51790

13

2

MS20601-AD4W3 Purchased No

190 Each 134.0000 12 12

MS20601-AD4W3

**

BE 15-03-04

Rivet

Location

Loc Qty

Loc Code

ST308

134

114538

18

m131340

116

12

ALS4-1032-225 AELS8-1032-225 Purchased No

260 Each 163.0000 1 1

ALS4-1032-225

**

HL 15/03/12

Rivnut

Location

Loc Qty

Loc Code

FG

120

M127028

120

M1131582

XL

FP001

43

M131067

43

Picklist Print

Friday, February 13, 2015 12:39:26 PM

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129557

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D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C4A	Purchased	No	260	Each	1,554.000	31	31	
AN3C4A								**
Bolt								15/03/12

Location	Loc Qty	Loc Code
FG	20	
122814	20	M131677
ST338a	1400	
M131320	400	
M131420	1000	
ST350	134	
M130716	134	

AN3C5A	Purchased	No	260	Each	1,089.000	2	2	
AN3C5A								**
Bolt								15/03/12

Location	Loc Qty	Loc Code
FG	5	
122800	5	
ST338a	662	
M130770	146	
M130851	16	
M131320	500	
ST350	422	
M131420	422	

AN526C1032R10	Purchased	No	260	Each	107.0000	2	2	
AN526C1032R10								**
Screw								15/03/12

Location	Loc Qty	Loc Code
FP001	2	
108062	2	
ST327	105	
m128712	105	

Picklist Print

Page 5

Friday, February 13, 2015 12:39:26 PM

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129557

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Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D2965

Manufactured No

260

Each

9.0000

1

1

D2965

Cap

all 15/03/12

Location

Loc Qty

Loc Code

FP001

9

99551

9

D2965-3

Manufactured No

260

Each

12.0000

1

1

D2965-3

Cap

all 15/03/12

Location

Loc Qty

Loc Code

FP001

12

120969

7

98923

5

D3492-1

Manufactured No

260

Each

188.0000

4

4

D3492-1

Plug

all 15/03/12

Location

Loc Qty

Loc Code

FP001

188

128509

173

129057

15

D3492-3

Manufactured No

260

Each

106.0000

4

4

D3492-3

Plug

all 15/03/12

Location

Loc Qty

Loc Code

FP001

106

125905

2

128476

104

13128914

x4

Picklist Print

Friday, February 13, 2015 12:39:26 PM

Page 6

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129557

Parent Item: D135-751-011

D135-751-011

Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D3492-7

Manufactured No

260

Each

104.0000

2

2

D3492-7

Plug

**

ll 15/03/12

Location

Loc Qty

Loc Code

FP001

104

106110

100

86759

4

V2

D4918-047

Manufactured No

260

Each

5.0000

1

1

D4918-047

Wearplate Aft

**

ll 15/03/12

Location

Loc Qty

Loc Code

FP001

4

123667

4

X1

ST609

1

119894

1

D4918-1

Manufactured No

260

Each

10.0000

1

1

D4918-1

Wearplate Fwd

**

ll 15/03/12

Location

Loc Qty

Loc Code

FP001

8

112525

2

X1

113348

6

FP002

2

119891

2

D4918-3

Manufactured No

260

Each

6.0000

1

1

D4918-3

Wearplate Center Fwd

**

ll 15/03/12

Location

Loc Qty

Loc Code

FP002

6

112352

2

X1

113301

4

Friday, February 13, 2015 12:39:26 PM

Shop Packet Print

Page 6

Picklist Print

Friday, February 13, 2015 12:39:26 PM

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Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

D4918-5

Manufactured No

260

Each

12.0000

1

1

D4918-5

Wearplate Center Aft

all 151031/12

Location

Loc Qty

Loc Code

FP002

12

112548

4

113349

3

115162

4

119893

1

81

NAS1149C0332R

Purchased

No

260

Each

3,891.000

33

33

NAS1149C0332R

WASHER

all 151031/12

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

2

125654

2

ST271

1749

125654

44

m130466

15

m131340

1690

x33
11131618

NAS1611-007

Purchased

No

260

Each

346.0000

2

2

NAS1611-007

O-RING

all 151031/13

Location

Loc Qty

Loc Code

FP001

346

103697

346

x2

Picklist Print

Friday, February 13, 2015 12:39:26 PM

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129557

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Parent Item Name: Skidtube with Standard Wearplates Fits LH or RH

Start Date: 2/13/2015

Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

260

Each

132.0000

4

4

NAS1611-010

O-RING

ll 15/03/12

Location

Loc Qty

Loc Code

FP001

132

m130797

4

11130770

✓

m131329

128

NAS1611-013

Purchased

No

260

Each

710.0000

4

4

NAS1611-013

O-RING

ll 15/03/12

Location

Loc Qty

Loc Code

FP001

710

m130758

710

✓

AN3C4A

Purchased

No

280

Each

1,554.000

8

8

AN3C4A

Bolt

DAS

46

9-89

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

20

122814

20

ST338a

1400

M131320

400

M131420

1000

ST350

134

M130716

134

D3512-041

Manufactured

No

280

Each

1.0000

2

2

D3512-041

Wearplate

DAS

46

9-89

130272

DAS
6
9-89

Location

Loc Qty

Loc Code

st612

1

125607

1

MAR 14 2015

Picklist Print

Friday, February 13, 2015 12:39:26 PM

Page 9

Work Order ID: 129557

129557

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Required Date: 2/13/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

280

Each

3,891.000

8

8

NAS1149C0332R DAS
WASHER

46
9-89

MAR 14 2015

Location

Loc Qty

Loc Code

FP001

2140

m130325

2140

GA

2

125654

2

ST271

1749

125654

44

m130466

15

m131340

1690

DAS

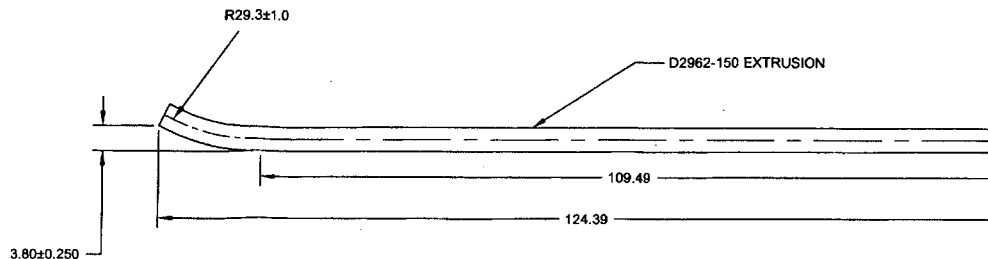
6

9-89

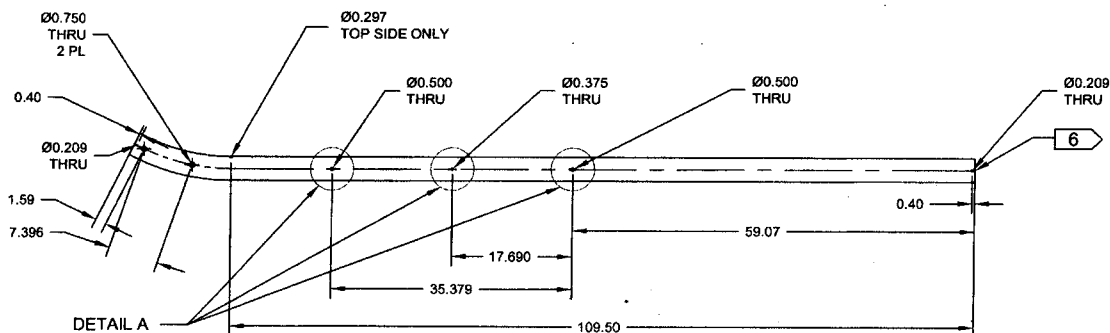
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3508-1	DOUBLER
2	D3508-3	DOUBLER
1	D4918-1	WEARPLATE
1	D4918-3	WEARPLATE
1	D4918-5	WEARPLATE
1	D4918-047	WEARPLATE
38	AEIS-1032-130	INSERT
1	AEIS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN860C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

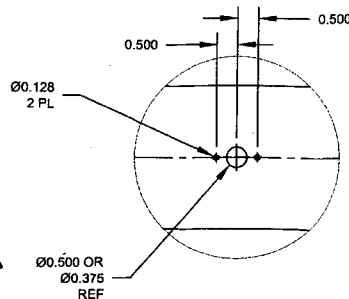
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB.
STANDARD: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
OPTIONAL: POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTERLINE PER DART QSI 005 4.4 (OPTIONAL)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART B/N PER DART QSI 044 6.4 (VIBRATING STYLUS) ON I.D. OF TUBE.
- 7) WEIGHT: 24.1 LB (FROM IIN-D135-751)
- 8) WELDING TO BE DONE PER DART QSI 004
- 9) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-281 ADHESIVE PER DART QSI 015 AFTER BENDING
- 10) USE DART DRILL TEMPLATE DTR889 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AEIS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-281.
- 11) DO NOT INSTALL AN3C4A BOLTS AND AN860C10L WASHERS IN INDICATED LOCATIONS



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL

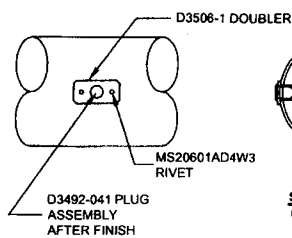


DETAIL A
TYP. 6 PL
SCALE 3:10

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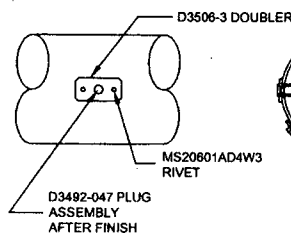
129557 MLC
1502-13

D	REMOVE D3558-X GASKETS, D4918-X WAS D3508-X REVISE FINISH TO ADD PAINT AS THE PREFERRED FINISH. REVISED NOTES	DW	13.08.30
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	08.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	EC 135 SKIDTUBE	NTS
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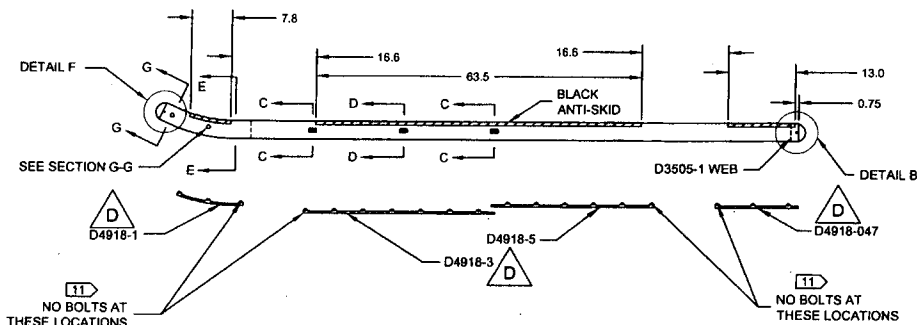
SECTION C-C
(SCALE 3:10)

- D3504-1 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.500 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-1 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.404 (Y DRILL) THRU HOLE
 5. INSTALL D3506-1 DOUBLER 4 PL USING MS20601AD4W3 RIVET 8 PL
 6. AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY 4 PL

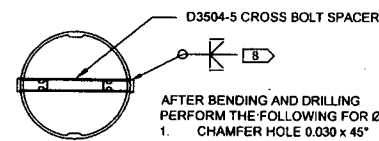


SECTION D-D
(SCALE 3:10)

- D3504-3 CROSS BOLT SPACER**
- AFTER BENDING AND DRILLING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-3 CROSS BOLT SPACER 1 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.277 (J DRILL) THRU HOLE
 5. INSTALL D3506-3 DOUBLER 2 PL USING MS20601AD4W3 RIVET 4 PL
 6. AFTER FINISH, INSTALL D3492-047 PLUG ASSEMBLY 2 PL

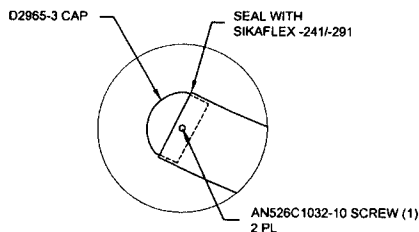


D3507-041 ASSEMBLY DETAIL

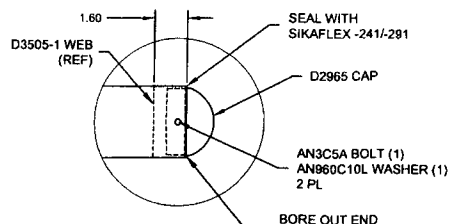


SECTION G-G
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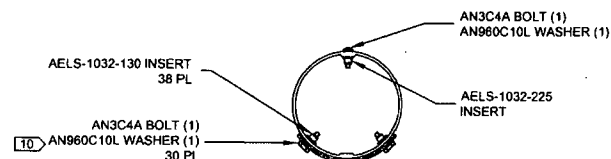
- AFTER BENDING AND DRILLING PERFORM THE FOLLOWING FOR Ø0.750 HOLES ONLY:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3504-5 CROSS BOLT SPACER 2 PL
 3. WELD INTO PLACE AND GRIND FLUSH
 4. IF REQUIRED, PASS Ø0.594 (Ø32 DRILL) THRU HOLE
 5. AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY 4 PL



DETAIL F
(SCALE 1:5)



DETAIL B
(SCALE 1:5)



SECTION E-E
(SCALE 3:10)

DESIGN	DW	DART AEROSPACE USA, INC	
DRAWN	DW	KENT, WA	
CHECKED	GP	DRAWING NO.	REV. D
MFG. APPR.		D3507	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EC 135 SKIDTUBE	NTS
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RELEASED
2013-12-10

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D135-751 REV. C
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D135-751 REV. 2

REF. FAA STC: SR01709SE
REF. EASA STC: EASA.IM.R.S.01278

PURPOSE:

THE D135-751-043 WEARPLATE KIT AT CHG 002 CONTAINS WEARPLATES WITH AN IMPROVED WEAR PATTERN AND A COATING THAT ELIMINATES THE NEED FOR THE RUBBER GASKETS. THE D135-751-011 SKIDTUBE INSTALLATION AT CHG 002 AND D135-751-041 REPLACEMENT SKIDTUBE AT CHG 002 CONTAIN THE NEW WEARPLATES.

THE DSI 9661-011 WEARPLATE UPGRADE KIT IS AVAILABLE TO UPGRADE EXISTING D135-751-011 KITS AT CHG 001 WITH IMPROVED AFT WEARPLATES.

CHANGE:

FOR D135-751-011/-041/-043 KITS AT CHG 002, THE WEARPLATE INSTALLATION PROCEDURE OF ICA-D135-751 SECTION 32.3 IS REVISED AS FOLLOWS. IF INSTALLING THE DSI 9661-011 WEARPLATE UPGRADE KIT, THE PARTS SHOULD BE INSTALLED USING THE FOLLOWING INSTRUCTION.

32.3 WEARPLATE REPLACEMENT

IF REINSTALLING D3508-X WEARPLATES ON D135-751-011/-041 KITS AT CHG 001, THE WEARPLATES SHOULD BE INSTALLED WITH D3558-X GASKETS PER ICA-D135-751 REV. 2. FOR D135-751-011/-041/-043 KITS AT CHG 002, THE WEARPLATES SHOULD BE INSTALLED WITHOUT GASKETS, AS INDICATED BELOW. IF D4918-X WEARPLATES ARE BEING INSTALLED ON D135-751-011/-041 SKIDTUBES AT CHG 001, THEY SHOULD LIKEWISE BE INSTALLED WITHOUT GASKETS AS INDICATED BELOW.

- 32.3.1 REMOVE WEARPLATES AND GASKETS (IF PRESENT) BY REMOVING THE AN3C BOLTS THAT SECURE THEM TO THE BOTTOM OF THE SKIDTUBE.
- 32.3.2 CHECK FOR CORROSION AND MECHANICAL DAMAGE IN ACCORDANCE TO CHAPTER 5 AND REPAIR AS REQUIRED. REFINISH BOTTOM OF SKIDTUBE PER CHAPTER 5 OF ICA-D135-751.
- 32.3.3 INSTALL REPLACEMENT D4918-1/-3/-5/-047 WEARPLATES USING AN3C BOLTS AS APPLICABLE AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTALLATION. INSTALL (QTY 2) D3512-041 WEARPLATES (ITEM 27) OVER FWD AND AFT CLAMPS AS SHOWN IN FIGURE 1 USING AN3C BOLTS AND AN960C10L WASHERS. TORQUE BOLTS 15-25 IN-LB (1.7-2.8 N-m). SEAL WEARPLATE INSERTS USING SIKAFLEX-241/-291 OR PROSEAL 890 MIL-S-8802 CLASS B2 SEALANT.

WEIGHT AND BALANCE:

USE THE FOLLOWING WEIGHT AND BALANCE INFORMATION FOR DART D135-751-011 SKIDTUBE INSTALLATION AT CHG 002.

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D135-751-011 CHG 002 <i>Skidtube Installation</i>	24.5 lb 11.2 kg	±39.4 in ±1.0 m	±966 in-lb ±11.2 m-kg	147.1 in 3.7 m	3604 in-lb 41.5 m-kg

A	NEW ISSUE	DW	13.08.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	<i>UP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REVISED WEARPLATE KIT	NTS
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PARTS LIST:

THE PARTS LISTS IN SECTION 32.9 OF ICA-D135-751 (PAGE 35) AND SECTION 5.0 OF IIN-D135-751 (PAGE 11) ARE AMENDED AS FOLLOWS FOR D135-751-011 @ CHG 002 AND LATER.

32.9 PARTS LIST (ICA-D135-751)**5.0 PARTS LIST (IIN-D135-751)**

Item	QTY -011	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X			D135-751-011	SKIDTUBE INSTALLATION
	1	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT

IS:

20A	1		1	D4918-1	WEARPLATE (REPLACES D3508-1)
21A	1		1	D4918-3	WEARPLATE (REPLACES D3508-3)
22A	1		1	D4918-5	WEARPLATE (REPLACES D3508-5)
23A	1		1	D4918-047	WEARPLATE (REPLACES D3508-7)
27	2		2	D3512-041	WEARPLATE (REPLACES D3512-1)

WAS:

20A	1		1	D3508-1	WEARPLATE
20B	1		1	D3558-1	GASKET
21A	1		1	D3508-3	WEARPLATE
21B	1		1	D3558-3	GASKET
22A	1		1	D3508-5	WEARPLATE
22B	1		1	D3558-5	GASKET
23A	1		1	D3508-7	WEARPLATE
23B	1		1	D3558-7	GASKET
27	2		2	D3512-1	WEARPLATE

THE PARTS LIST FOR THE DSI 9661-011 KIT IS AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9661-011	WEARPLATE UPGRADE KIT
1	D4918-047	WEARPLATE
2	D3512-041	WEARPLATE

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DRAWN	DW		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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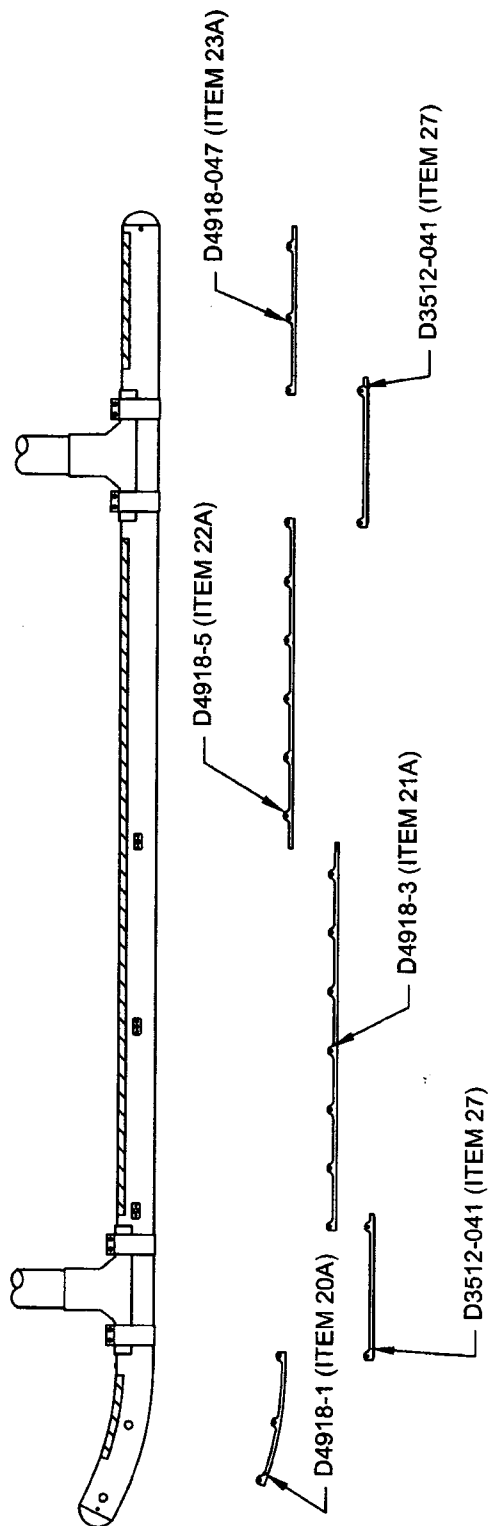


FIGURE 1: WEARPLATE INSTALLATION

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DRAWN	DW		
CHECKED	<i>OP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REVISED WEARPLATE KIT	NTS
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